

Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM

SPL-1 Blue



Page 1

Item ID: D3414-041

Accept



Setup

Start



Revision ID:

Item Name: Lug Assembly

Start Date: 7/6/2011

Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011

Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: CSL

Date: 11/07/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3414	Rev C	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>								
304 100	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

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Item ID: D3414-041

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Setup

Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

8 u(57)13

cont'd  
724

Quality Control

130



Brake NC

Memo

0.00

SB u(57)14

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

140



Large Fab

Memo

0.00

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414  
A/R S.S. welding rod Batch: M101822

M112659

A 11-1-28 D

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Item ID: D3414-041

Accept



Setup

Start



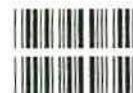
Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

11-07-29

(7)

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

Sulzlorz

(7)

QC

Memo

0.00

Quality Control

170

White Gloss(Ref4.3.5.1) per QSI005 4.3-Alum

0.00

ZT 11-08-04

Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

175

Spray paint

Prime B 117319  
Defllet Blue B 118395  
Clear B 118053

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Item ID: D3414-041

Accept

Revision ID:

Item Name: Lug Assembly

Setup

Start



Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC1- Inspect Part Finish

Memo

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

①

② 11.08.05

190



Packaging

Packaging

Identify as per dwg &amp; Stock Location: ST420

0.00

Memo

0.00

②

③ 11/08/05

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

④ 11/08/05

⑤ 11/08/05

# Picklist Print

Wednesday, July 06, 2011 1:20:11 PM

Page 1

Work Order ID: 71572



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA



304/316 0.100" Sheet

Purchased

No

100

sf

147.3000

0.155

2.48



BLH-7-13

D3414-3



Manufactured

No

140

Each

21.0000

1

16



EL 11-7-28

Lug

Location	Loc Qty	Loc Code
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MAT019

147.3

113062

118.3

113077

29

WA

21

69882

21

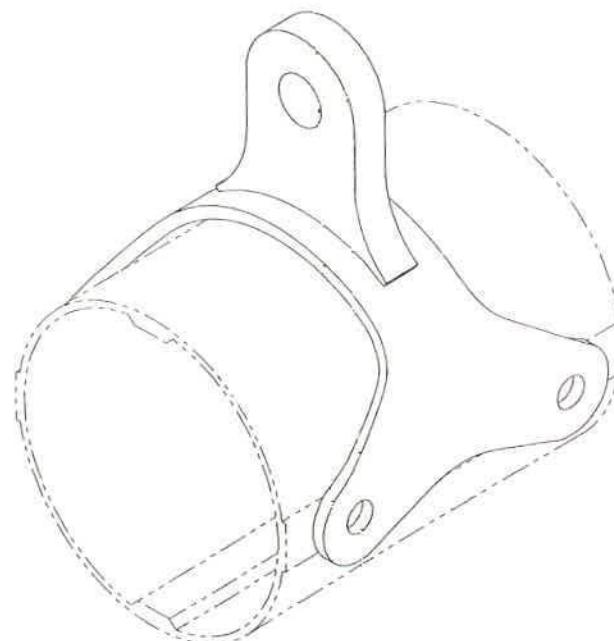
70412

x7

113077

24

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

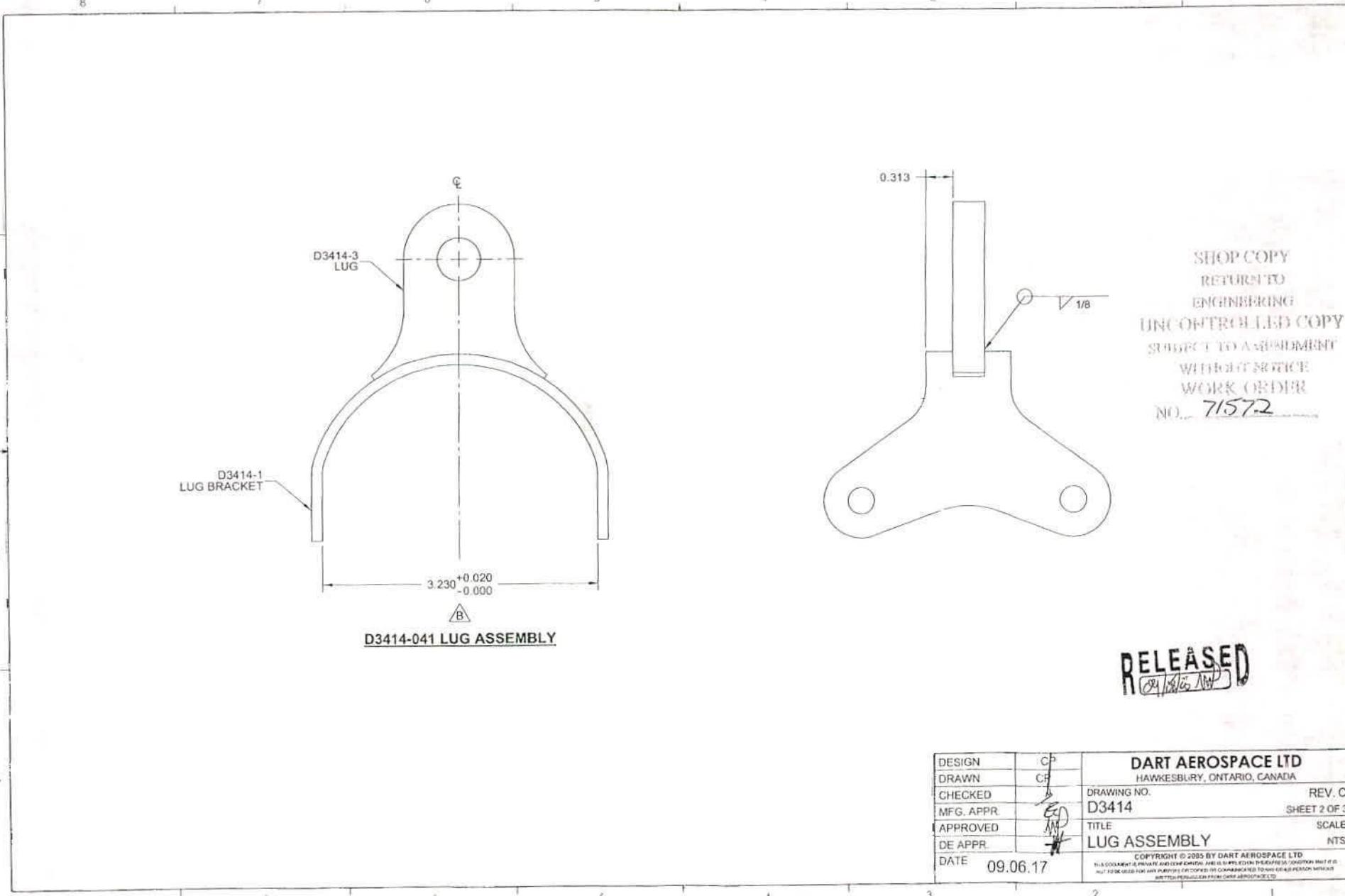
NOTES:

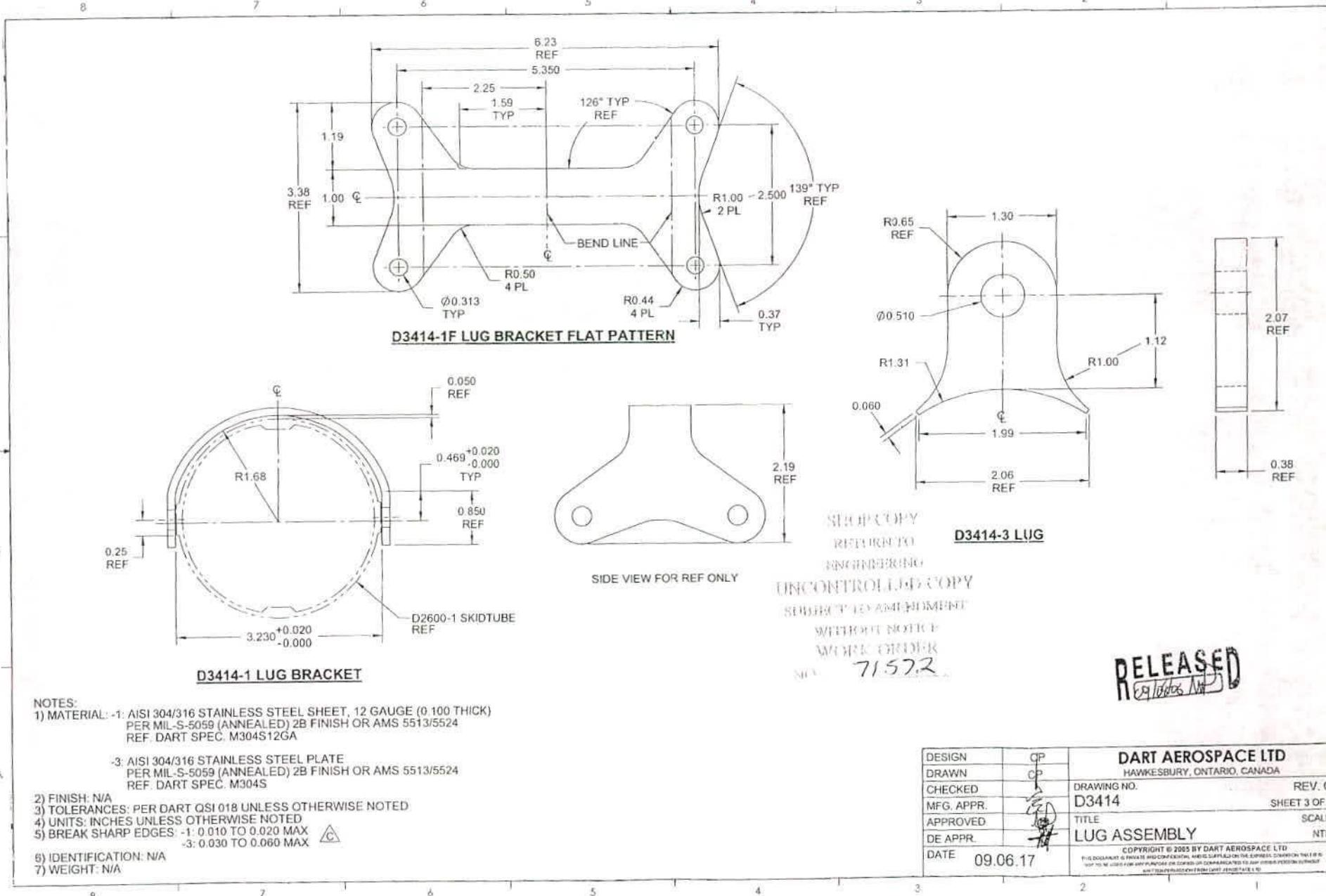
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WHEN ISSUED  
S/C/C/C/C/C/C/C/C  
71572  
CL1107106

RELEASED  
07/06/2014

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER: FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3.1.12 DIM WAS 1.20	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE KEPT ON THE COMPANY'S PROPERTY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





DART AEROSPACE LTD	Work Order:	71572
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414      Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-7-13	Date: 11/07/13	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	 